



007006

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

SK393M44121-1
Job Sheet 185712



Part No: SK393M44121-1

Job Qty: 1 ea

Part Name: Alignment Set, Belt



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/31/18

Job Tracking No:

Due Date: 12/5/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SK393M44121 Rev. 0 IPP Rev. A 18.05.25 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/5/18	0.00	0.00	Start Up Small Fab-4		MLC
110	Small Fab	1 pcs		12/5/18	0.00	0.20	Small Fab-4		MLC
120	QC	1 pcs		12/5/18	0.00	0.00	QC#5		MLC
130	Packaging	1 pcs		12/5/18	0.00	0.00	Packaging3-1		DEC 11 2018
140	QC21-FG	1 Ea		12/5/18	0.00	0.00	QC21		DEC 11 2018

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1450-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	90-Start up Operation	5089128
APP-1450-E	Case	1 Ea (1 ea)	90-Start up Operation	5128222
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	90-Start up Operation	5021040
2310A15	Magnetic Base	1 Ea (1 ea)	110-Small Fab	5124850
5165A24	C-Clamp	2 Ea (2 ea)	110-Small Fab	5124857
8591A61	Dial Indicator	1 Ea (1 ea)	110-Small Fab	5135942
88775K151	Stainless Bar	1 ft (1 ea)	110-Small Fab	5124857
SK393M44121-1A	Bottom Pad used in case APP-1450-E	1 Ea (1 ea)	110-Small Fab	5128219
SK393M44121-1B	Lid Foam used in case APP-1450-E	1 Ea (1 ea)	110-Small Fab	5128221

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	97524A032	4	735	0
	APP-1450-E	1	17	0
	RB41011	1	712	0
	2310A15	1	0	0
110-Small Fab	5165A24	2	0	0
	8591A61	1	0	0
	88775K151	1	0	0
	SK393M44121-1A	1	0	0
	SK393M44121-1B	1	0	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

Part Specifications

Specifications could not be found.

Plex 10/31/18 1:45 PM Dart.lajeunesse.marie

DART
AEROSPACE

Container No: S136910

Part: SK393M44121-1

Job No: 185712

Serial No/Batch: S136910

Revision: 0

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/11/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

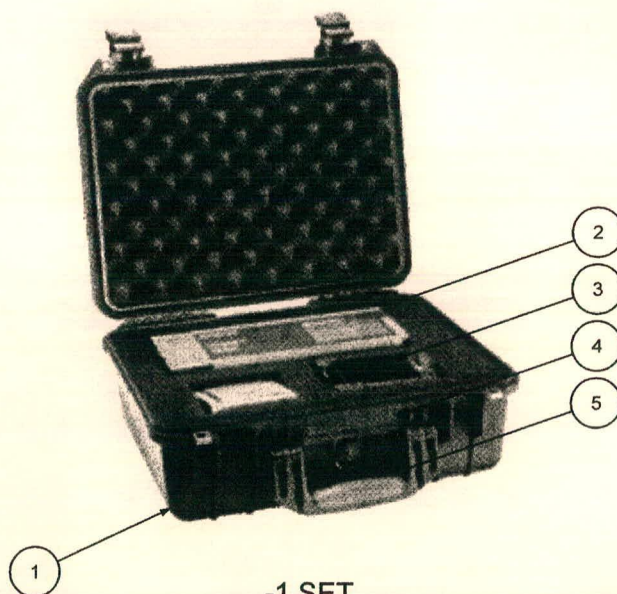
Work Order update only ☐

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Root Cause				FAULT CATEGORY			
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Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
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Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
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Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

Notes:

- 1.FN 1 Case is provided with polyurethane foam in base and convoluted foam in lid. Seller will establish position of contents within base that provides protection and will cut out foam to firmly retain contents. FN 2 Indicator and FN 3 Magnetic Base and Clamps/Rods shall be retained inside original packaging. Turn in adjusting screw on FN 4 Clamps to achieve minimum packing size.
2. Apply Buyer-furnished FN 6 Nameplate on top side of Case.



-1 SET

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	ORIGINAL RELEASE	1/7/2006	CPK

NORTHROP GRUMMAN Integrated Systems		DATE: 1/7/07
NAME OF PART: ALIGNMENT SET, BELT DRIVE RUNOUT		
SK393M44121-1	MQ-8B	
N00019-00-C-0277	(PER CONFIG MGMT)	

FN.6 NAMEPLATE DETAILS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 185712 MJS
1870-31

ITEM	QTY	PART NO.	DESCRIPTION
6	1	87102-13	NAMEPLATE, NORTHROP GRUMMAN (BUYER FURNISHED)
5	1	88758-151	STAINLESS STL BAR, 17.4 PH 12" X 3" X 12" MILL FINISH, ASTM A304 (B) MASTER-CARR OR EQUIV
4	2	5133A16	C-CLAMP, LIGHT FORCE, REG PATTERN, 4 IN CAP (B) MASTER-CARR OR EQUIV
3	1	2510A16	MAGNETIC BASE W/CLAMP (B) MASTER-CARR OR EQUIV
2	1	8801411	TEST INDICATOR, 0 - 0.018 RANGE - STARRETT MODEL #11-1CZ (B) MASTER-CARR OR EQUIV
1	1	APP-14096P	CASE, TRANSIT (PELICAN PRODUCTS, INC)

CONTRACT NO. N00019-00-C-0277		NORTHROP GRUMMAN Ryan Aeronautical Center	
SIGNATURES	DATE	ALIGNMENT SET, BELT DRIVE TRANS PINION RUNOUT	
C. KOWAL	1/7/2007	REV. D	78022
		SK393M44121	PR

